

Date: Monday, 05/05/2008 11:11:58 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CC-DAR01 Dart Aerospace Ltd.	<b>Drawing Name</b> : CUSHION ASSEMBLY
<b>Job Number</b> : 39035	
<b>Estimate Number</b> : 13299	
<b>P.O. Number</b> :	<b>Part Number</b> : D3781041
<b>This Issue</b> : 05/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : PRELIM
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : // <b>Type</b> : R & D SM/MED FAB	<b>Drawing Revision</b> : PRELIM
<b>Previous Run</b> :	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 12/05/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:A 08-05-02 new issue DD verified by:EC	

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

~~PRELIMINARY ISSUE~~

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Pick Packing Kit

2.0	D37813	Cushion
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Cushion B39037  
 batch: M108144

080527

3.0	D37811	Supporting Plate
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 Supporting Plate  
 batch: B39036

080515

1

4.0	MS21075L3	Nutplate
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)  
 Nutplate  
 batch: M107279

080515

4

5.0	MS20426AD3	Rivet
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)  
 Rivet M105978  
 batch: M11179

080515

8

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 05/05/2008 11:11:59 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: CUSHION ASSEMBLY

Job Number: 39035

Part Number: D3781041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- assemble nut plate as per dwg D3781

2- bond cushion to supporting plate using Hydra Fast-En DC-13431 adhesive as per dwg D3781

(DC-13431) batch: M105623

08.05.30 ACCEPTABLE / NOT RECD FOR TEST  
SCOTCH GRIP 1357 High Performance

080515

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08.05.30

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # and batch # using a fine point permanent marker on inside of part and Stock

Location: \_\_\_\_\_

NA

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Plorony 08.06.07

MR 08-06-16

Job Completion



POSITIVE RECALL

EFFECTIVE

08.05.30

AUTH

U

RELEASED

DATE

08.05.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-761

Job #: 00224A

Date: 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

Requested By: \_\_\_\_\_

Design Manager Approval: \_\_\_\_\_

Quantity	Part Number	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
5	D3701-1F	FLOOR DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3702-1	FORWARD DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-1F	AFT DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-3F	AFT CORNER DOUBLER	08.04.30	Y	08.05.02	FOR TESTING	
5	D3703-5	AFT CAP	08.04.30	Y	08.05.02	FOR TESTING	
1	D3785-041	ARMREST WELDMENT	08.04.29	N/A	08.05.12	FOR TESTING	
2	D3785-1	TUBE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-3	BRACKET	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	
2	D3785-5	FIXTURE	08.04.29	Y	WEEK OF 08.05.05	FOR TESTING	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# PROTOTYPE REQUEST FORM

**DART Aerospace Ltd.**

Product #: D412-761

**Job #:** 00224A

**Date:** 08.04.30

Product Name: FULL VERTICAL REFERENCE DOOR

**Requested By:**

**Design Manager Approval:**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

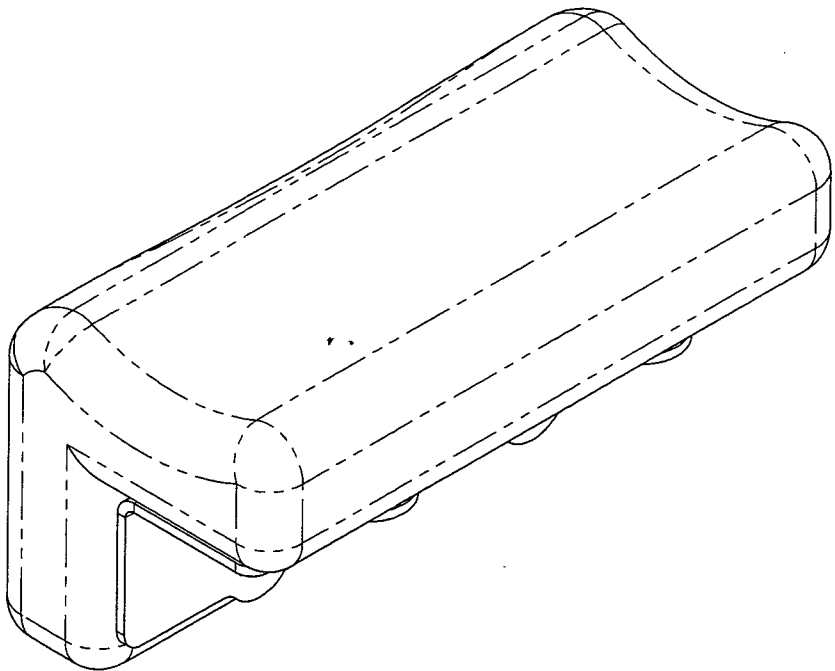
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041	P/N	DESCRIPTION
X	D3781-041	CUSHION ASSEMBLY
1	D3781-3	CUSHION
1	D3781-1	SUPPORTING PLATE
A/R	DC-13431	HYDRA FAST-EN ADHESIVE
4	MS21075-3	NUT PLATE <i>or MS21075L3</i>
8	MS20426AD3-5	RIVET

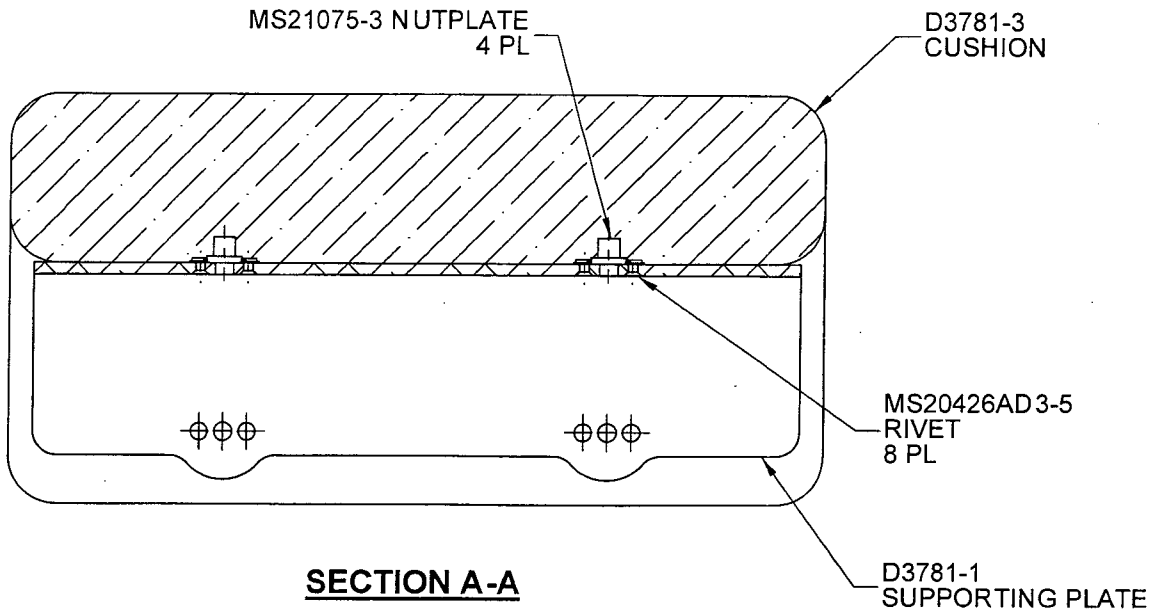
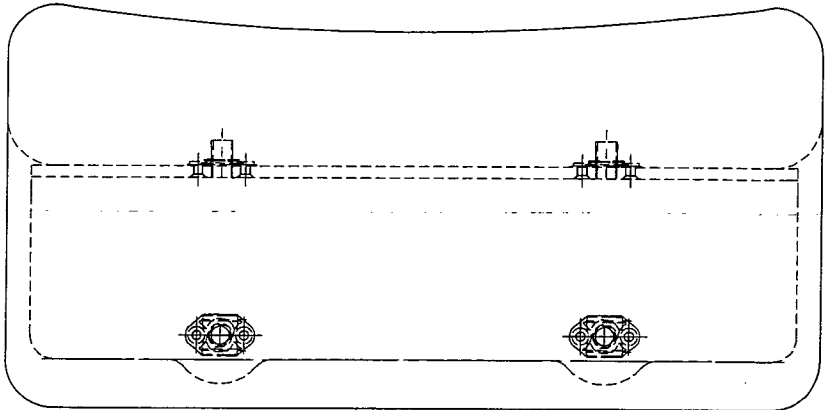
08.05.15



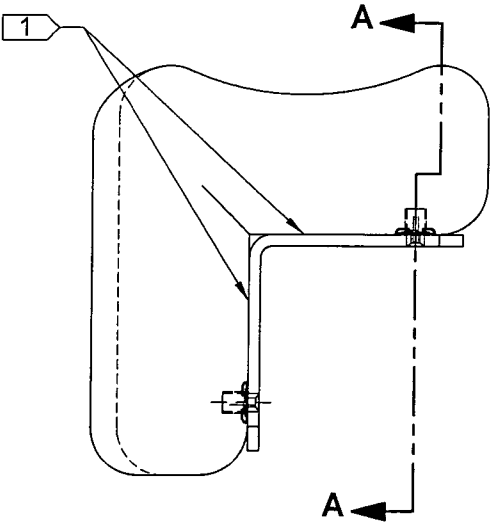
D3781-041 CUSHION ASSEMBLY

PROTOTYPE  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
~~PRELIMINARY ISSUE~~  
~~PRELIMINARY ISSUE~~  
08.04.30

A	NEW ISSUE	MB	08.04.29
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3781	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CUSHION ASSEMBLY	NTS
DATE	08.04.29	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



SECTION A-A



- D3781-041 NOTES:
- 1) MATERIAL: BOND D3781-3 CUSHION TO D3781-1 SUPPORTING PLATE USING HYDRA FAST-EN DC-13431 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
  - 2) FINISH: COVER CUSHION ASSEMBLY WITH
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3781-041" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.84 lbs